

FUJI-IMVAC

Operator's Manual for BT-24M



SPECIFICATIONS

Displacement:	1.45 cu in [23.9cc]
Horsepower:	3.0hp [2.18kw]
Ignition Style:	Spring-Assisted Recoil Starter
R.P.M.:	4000 - 12,000rpm
Fuel:	Gas/2-cycle engine oil
Weight w/Muffler:	3.13 lbs [1.4kg]

**Manufactured by FUJI-IMVAC INC.
YOKOHAMA, 235-0005 JAPAN**
**Worldwide Distributor (except Japan): Hobbico, Inc.
Champaign, IL 61826 USA**
www.fuji-imvac.com

Fuji-Imvac is not related to the original Fuji Engines sold by Mecoa.

SAFETY TIPS AND WARNINGS

- Always use a balanced prop. An unbalanced prop will cause high levels of vibration that may be harmful to your driveshaft and engine.
- Be sure to keep your driveshaft well lubricated. Failure to do so may cause vibrations that can be harmful to the engine. Re-lubricate your driveshaft every 2-3 runs.
- Keep foreign objects away from the propeller. Never start the engine on loose gravel or sand.
- Keep onlookers away from the running engine, especially small children.
- Do not attempt to stop the engine by throwing anything into the path of the propeller or by grabbing the driveshaft.
- Make sure the fuel line is well-secured to the engine and to the fuel tank so that it won't come off while in use.
- Do not use silicone fuel line because it will be attacked by the gasoline. Use vinyl or neoprene rubber fuel line.
- Always secure the fuel line away from the cylinder head. The engine's heat can damage the fuel line.
- Muffler pressure to the fuel tank is not required.
- Never touch the engine or exhaust system after a run. Parts of the engine and exhaust will be hot and may burn you.

- Before transporting your model, remove all of the gasoline from the tank and lines.
- Always use high quality oil intended for 2-cycle engines.
- Use only low-octane, alcohol-free gasoline. The carburetor diaphragm will gradually deteriorate if you use gasoline with alcohol. You will need to replace the diaphragm in about 80 hours of operation if you use gasoline with alcohol.
- Do not install your throttle servo inside the engine compartment. Doing so could cause radio interference. Install all electronic radio devices at least 12" [305mm] away from the engine.
- If you are not planning to run your engine for more than a month, drain the fuel tank and remove any fuel from inside the carburetor. Do this by running the engine at idle until it quits by running out of fuel. Keeping gasoline inside the carburetor over an extended period of time will damage the diaphragm valve and clog passages inside the carburetor.
- Because the carburetor is more complicated than those used in glow engines, keep the fuel clean by using a fuel filter. Use a filter intended to be used with gasoline engines. Metal filters intended for glow engines are too coarse and will not screen out finer particles.
- If you intend to run this engine on an engine stand, or on any other rigid mount, use hard rubber isolation mounts. The crankcase and other parts of the engine may crack if you do not provide some kind of vibration absorption mechanism.
- Do not operate the engine in a closed room or where ventilation is not adequate.
- Gasoline is extremely flammable. Keep it away from an open flame, excessive heat or sources of sparks. Do not smoke or allow anyone else to smoke near the engine or the fuel tank.
- This engine was designed for use in model boats. Do not attempt to use it for any other purpose.

PREPARING THE ENGINE

1. Check to see that all screws and bolts are tight. Check carefully for any cracks, broken or missing parts. Tighten or replace before proceeding.
2. Install the spark plug in the cylinder head.

SPARK PLUG

The recommended spark plug is a Champion RCJ-6Y. To avoid improper operation or possible engine damage, do not use any other type of spark plugs. The plug gap should be 0.016" to 0.024" [0.4mm to 0.6mm]. If the plug gap is incorrect, adjust it with a spark plug gapping tool, wash it with gasoline and allow it to dry completely before you reinstall the plug in the engine.

INSTALLING THE FUJI-IMVAC BT-24M IN YOUR BOAT

Note: The Fuji-Imvac BT-24M must be installed onto mounting rails which are then mounted to your hull's mounting lugs. Use hard rubber isolation mounts between the mounting rails and lugs. The instructions listed here describe a typical gas boat installation and do not necessarily apply to all makes and models. It is a good idea to consult your hull manufacturer's instruction manual for proper mounting procedure.

1. Place the BT-24M on your boat's mounting rails. Mark and drill the engine mounting bolt holes on the mounting rails.
2. Fasten the engine onto mounting rails using four 4mm socket head cap screws and four 4mm lock washers. It is a good idea to use some threadlocking compound, such as Great Planes® Pro™ Threadlocker (GPMR6060), on the screws.
3. Install the engine and mounting assembly into your boat. (Consult the manual that came with your hull for proper mounting position)
4. Attach the fuel line to the carburetor. It is a good idea to use a retaining clip to hold the line in place. Use only gasoline-safe fuel line. One line should go to the carburetor and the other is to be used as a vent. You can fill the tank by using the carburetor line as fill line if you have access to it or install a third line to be used as fill line.
5. Install the throttle servo at least 12" [305mm] away from the engine. Make sure that you get the carburetor's full range of rotation with your servo travel.
6. Attach the water cooling lines to the cylinder head.

Optional:

7. Mount a kill switch in a secure manner inside the engine compartment. Make sure that it is easily accessible and away from engine components that may be hot.

BEFORE OPERATION

- Go through the safety tips and warnings at the beginning of this manual to ensure a successful and safe engine run.
- Prepare only the amount of gasoline needed. Aged gasoline could damage the engine and cause it to overheat.
- If the engine was just run, make sure you allow enough time for it to cool down before you run it again. It is important to clean up any excess fuel that may have leaked inside the hull.
- Check to see that there are no foreign objects in the path of the propeller. Secure any loose articles of clothing so they cannot be drawn into the propeller.
- Fill the boat's fuel tank with the adequate gasoline mix.

BREAK IN THE ENGINE

To break-in your BT-24M, you need to run the engine for about an hour with a fuel mixture that contains a 25:1 (4% oil) fuel/oil ratio. The engine's output power will increase gradually over the first few tanks.

- Do not adjust the high-speed needle on the carburetor to break in the engine. If you do so, carbon will accumulate in the spark plug and that will make ignition difficult.
- Do not run at full power for extended periods of time while breaking in your engine.
- Make sure that the engine has adequate cooling.

RUNNING THE FUJI-IMVAC BT-24M IN YOUR BOAT

Once the engine is broken in, use 40:1 (2.5% oil) fuel/oil mix.

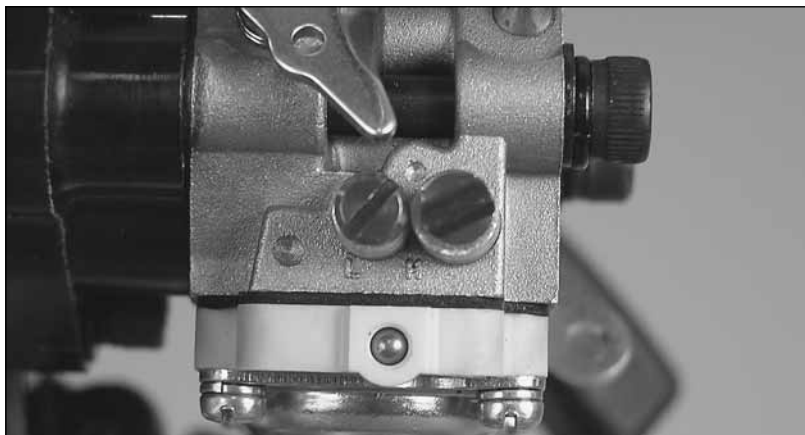
STARTING PROCEDURE

Helpful Tip: It is a good idea to have someone hold the boat in place while you start the engine.

1. Depress the priming bulb 3-5 times. This will begin the flow of fuel into the carburetor.
2. Close the choke on the carburetor and pull the handle of the recoil starter until you hear some initial firing sounds.
3. Quickly open the choke and pull the handle of the recoil starter until the engine starts.
4. After starting, let the engine idle for 30 seconds. Open and close the throttle slowly until the engine runs smoothly at idle and at full throttle. Acceleration should also be smooth.
5. If your engine does not start, repeat the starting procedure.

ENGINE ADJUSTMENTS

- Always make high and low speed needle adjustments while the engine is not running.
- Adjust the needle marked “H” for high speed rpm. Adjust the needle marked “L” for low speed rpm.



Normal high and low-speed needle settings:

It is not necessary to change the needle settings if the engine runs smoothly. Normally only the “H” needle will need adjustment from time to time and only by a small amount.

H: Open the needle 3/4 of a turn from the closed position ($\pm 1/4$ of a turn in cold weather).

L: Open the needle 1-3/8 turns from the closed position ($\pm 1/4$ of a turn in cold weather).

Only adjust the high and low speed needle within the above range.

Idle adjustment:

Important: Do not confuse the idle screw with the low speed needle “L”. The idle screw physically adjusts how much the carburetor valve can close. The low speed needle “L” adjusts the gasoline to air mixture when the engine is running at low rpm. If your engine appears to work correctly except that the low rpm are not as low as you want them to be, then adjust the idle screw. If your engine behaves erratically at low rpm, then adjust the low speed needle “L”. When adjusting, turn the screw about 1/8 of a turn each time. A dirty plug will make it difficult to adjust the idle rpm. Follow the recommended procedures if any of the following happens:

Problem:

- The engine hesitates when accelerated rapidly.
- The rpm increases at idling.
- The engine stops when the throttle is moved from high to low.

Solution:

Your low speed needle “L” is too lean. Open it up about 1/8 turn and try again.

Problem:

- The idle is not steady.

Solution:

Your low speed needle “L” valve is too rich. Close it 1/8 turn and try again.

High Speed Adjustment:

The high speed rpm and transition performance is adjusted with the high speed “H” needle valve. When adjusting, turn the screw about 1/8 of a turn each time. The position of the “H” needle will vary according to temperature and elevation. If your engine is running smoothly then do not adjust this needle valve. Follow the recommended procedures if any of the following happens:

Problem:

- Engine stops at full throttle.
- Engine hesitates when accelerated rapidly.
- The engine will not come up to full rpm at full throttle.

Solution:

Your high speed needle valve “H” is too lean. Open it up 1/8 turn and try again.

Problem:

- Your engine does not reach full rpm.
- Carbon build-ups appear consistently on your spark plug.

Solution:

Your high speed needle valve “H” is too rich. Close it up 1/8 turn and try again.

3-Year Limited Warranty For USA and Canada

Fuji-Imvac warrants this product to be free from defects in materials and workmanship for a period of three (3) years from the date of purchase. During that period, Fuji-Imvac will, at its option repair or replace without service charge any product deemed defective due to those causes. You will be required to provide proof of purchase date (receipt or invoice).

- This warranty does not cover damage caused by crash, abuse, misuse, alteration or accident. Damage caused by customer disassembly, tampering, use of substandard fuel, use of incorrect accessories (spark plug, prop, etc.) or any use of the engine for which it is not specifically intended will automatically void the warranty of the engine. If there is damage resulting from these causes within the stated warranty period, Fuji-Imvac will, at its option, repair or replace it for a service charge not greater than 50% of the current retail list price. Be sure to include your daytime telephone number and e-mail address in case we need to contact you about your repair.
- Under no circumstances will the purchaser be entitled to consequential or incidental damages. This warranty gives you specific legal rights and you may also have other rights, which vary from state to state.
- If you attempt to disassemble or repair this unit yourself, it may void the warranty.

For service on your Fuji-Imvac product, either in or out of warranty, send it post paid and insured to:

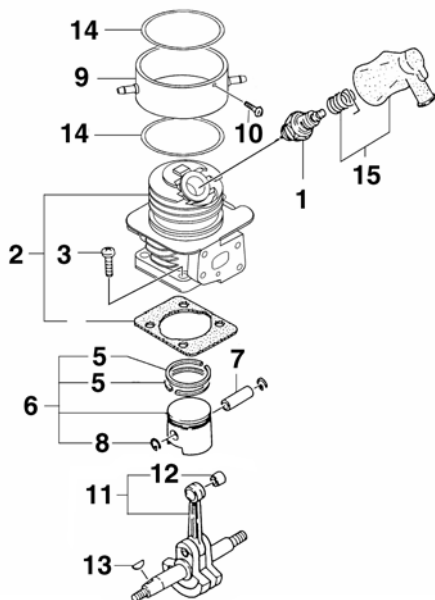
Hobby Services
3002 N. Apollo Drive, Suite 1
Champaign, IL 61822 U.S.A.
(217) 398-0007
www.hobbyservices.com

Along with your engine and proof of purchase date, please include a complete written explanation detailing the problem(s) and a phone number that you can be reached at during the day. State your name and return address clearly. For repairs not covered under warranty, you must specify whether you wish the charges to be billed COD or if you wish to be notified of the charges so you can send a check.

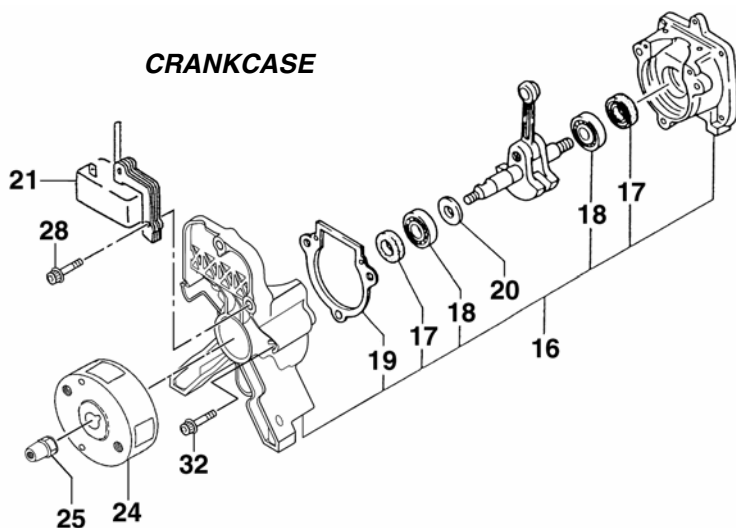
Outside USA and Canada, contact local importer for warranty information.

REPLACEMENT PARTS LIST CYLINDER/PISTON/CRANKSHAFT

Key #	Part #	Description
1.....	FJIG7470	Spark Plug RCJ-6Y
2.....	FJIG4441	Cylinder Set
3.....	FJIG8290	Hex Bolt 5x18/S
4.....	FJIG4291	Cylinder Gasket
5.....	FJIG6635	Piston Ring
6.....	FJIG6361	Piston Set
7.....	FJIG6419	Piston Pin
8.....	FJIG6509	Piston Pin Circlip
9.....	FJIG8719	Water Jacket Complete
10.....	FJIG7160	Screw 3x8
11.....	FJIG4019	Crankshaft Complete
12.....	FJIG6149	Needle Bearing 1.4x8.5
13.....	FJIG7660	Woodruff Key
14.....	FJIG6260	O-Ring
15.....	FJIG7500	Spark Plug Cap Assembly

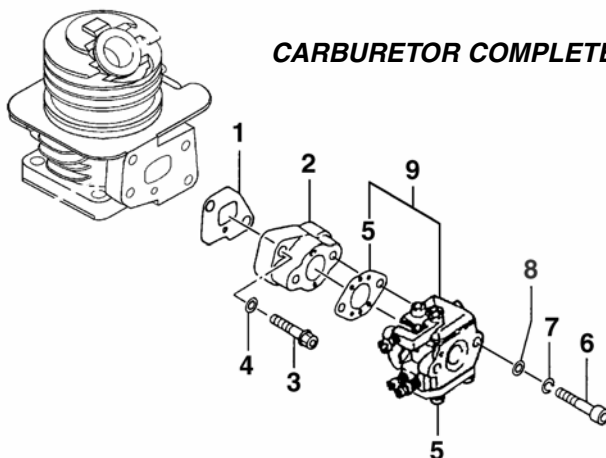


CRANKCASE



Key #	Part #	Description	
16.....	FJIG3830	Crankcase Assembly	20* FJIG7312Gear Shaft Shim 0.20
17.....	FJIG6300	Oil Seal TB12227	20* FJIG7313Gear Shaft Shim 0.30
18.....	FJIG3080	Ball Bearing 6001 C3	21..... FJIG5315 Ignition Coil Complete
19.....	FJIG3920	Crankcase Gasket	24..... FJIG0020 Magneto Rotor 60mm
20* FJIG7310		Gear Shaft Shim 0.10	25..... FJIG0020 Adapter
20* FJIG7311		Gear Shaft Shim 0.15	28..... FJIG8220 Hex Hole Bolt 4x18WS
			32..... FJIG8290 Hex Hole Bolt 5x18S

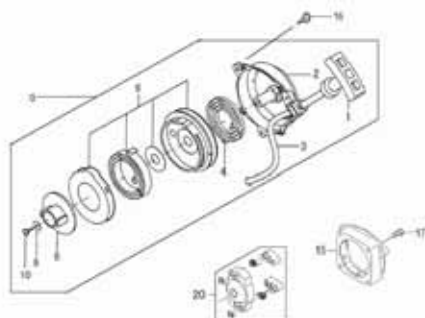
CARBURETOR COMPLETE



Key #	Part #	Description	
1.....	FJIG5480	Insulator Gasket	5..... FJIG3110 Carburetor Gasket
2.....	FJIG5515	Insulator Set	6..... FJIG8340 Hex Hole Bolt 5x50
3.....	FJIG8305	Hex Hole Bolt 5x22/S	7..... FJIG8605 Washer 5mm
4.....	FJIG8645	Small Washer 5mm	8..... FJIG8645 Small Washer 5mm
			9..... FJIG3230 Carburetor Set

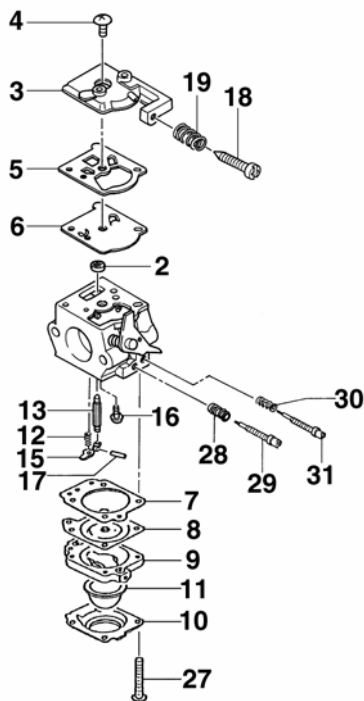
RECOIL STARTER

Key #	Part #	Description
2.....	FJIG5460	Inlet Screen
0.....	FJIG7130	Recoil Start Body Assembly
1.....	FJIG7134	Starter Handle
2.....	FJIG7131	Recoil Start Body Complete
3.....	FJIG7132	Recoil Rope
4.....	FJIG7133	Recoil Spring
6.....	FJIG7135	Spring Case
8.....	FJIG7136	Sarter Pulley
9.....	FJIG8606	Special Washer 5.2x15
10.....	FJIG7164	Tapping Screw 5x14
15.....	FJIG7137	Starter Base
16.....	FJIG7162	Tapping Screw 4.5x14
17.....	FJIG8190	Hex Hole Bolt 4x12WS
20.....	FJIG7138	Starter Pulley Assembly



CARBURETOR

Key #	Part #	Description
2.....	FJIG5460	Inlet Screen
3.....	FJIG6930	Pump Body
4.....	FJIG7170	Set Screw
5.....	FJIG7060	Pump Gasket
6.....	FJIG7020	Pump Diaphragm
7.....	FJIG4610	Diaphragm Gasket
8.....	FJIG5760	Metering Diaphragm Comp
9.....	FJIG3020	Air Purge Comp
10.....	FJIG4520	Diaphragm Cover
11.....	FJIG6210	Priming Body
12.....	FJIG8525	Valve Spring
13.....	FJIG6240	Needle Valve
15.....	FJIG7540	Valve Hinge
16.....	FJIG5130	Hinge Pin Set Screw
17.....	FJIG5100	Hinge Pin
18.....	FJIG5220	Idle Adjust Screw
19.....	FJIG5285	Idle Adjust Spring
27.....	FJIG7161	Set Screw
28.....	FJIG5070	High/Low Adjust Spring
29.....	FJIG5590	Low Adjust Screw
30.....	FJIG5040	High Adjust Spring
31.....	FJIG4940	High Adjust Screw



OPTIONAL MUFFLER & ACCESSORIES

FJIG5990	Muffler Set
GPMG2150	Engine Kill Switch

Key #	Part #	Description
1.....	FJIG5810	Muffler Gasket
3.....	FJIG8120	Hex Hole Bolt 5x70
4.....	FJIG8606	Special Washer B
5.....	FJIG5991	Muffler Special Gasket
6.....	FJIG8710	Tail Pipe Set
7.....	FJIG7165	Screw 4x8/S
8.....	FJIZ1140	Instruction Manual
9.....	FJIG3680	Combi Box Spanner
11.....	FJIG7166	Screw 4x16/PS

